

Glossy Black

Work Order ID 109333

109333

Page 1

November-19-13 12:50:23 PM

Item ID: D350-636-011GB

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/19/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/26/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2750-041

G

0.00

100

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

record fwd angle:

87.65

Photocopy blue file and type labels per PPP D350-636-011 CHG 007

13/11/13
mld

B109333LH

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Item ID: D350-636-011GB

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/19/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 11/26/13 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

Skidtubes

0.00

Skidtubes

Memo

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside
AFT end per dwg D27503- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500",
deburr.4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade
fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill
Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.
SECOND SIDE8-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting
location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up
holes for ground handling and detail C to 0.500" (8 holes per side)9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to
0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

BB 3/11/19

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Item ID: D350-636-011GB

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/19/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 11/26/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod batch: 1126325 BE13-11-19

12-Grind welds flush as per Dwg D2750 BE13-11-19

120

120

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

SKP
13-11-20

1

130

130

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

SKP
131120

1

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Item ID: D350-636-011GB

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/19/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 11/26/13 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.00							
Quality Control									

13-11-20 JCL

1 3B 13/11/20

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Item ID: D350-636-011GB

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Stop ***NS2***

Start Date: 11/19/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 11/26/13 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

160

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI015

A/R Sikaflex-291 batch: 27317 exp. date: 14/08/16

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 8)

A/R Aluminum Rod batch: m126325

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

BB 13/11/20

BE 13/11/21

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Item ID: D350-636-011GB

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/19/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 11/26/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Spot face ground handling holes section (total of 4 places per side) as per
dwg D2750

12-Deburr holes

170

QC10- Inspect visual per QSI004- ground welds

0.00

DAS

27

9-89

170

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

DAS

27

9-89

180

QC

Memo

0.00

Quality Control

VERIFY C'BOARD IS GOOD

DEF-11-21

B/11/21

B/11/21

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Item ID: D350-636-011GB Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.
 Start Date: 11/19/13 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 11/26/13 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.	0.00 0.00				1	0	CF	13-11-21
200 *200* SprayPaint Spray Painting	1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: <u>126543</u> 2- PAINT <u>Glossy Black - Iron</u> AS PER DWG AND QSI 005 4.2 PAINT BATCH: <u>127534</u>	0.00 0.00				1	0	0	13-11-21
210 *210* QC Quality Control	QC14- Inspect Spray Paint Memo Inspect for foreign object per QSI 024	0.00 0.00				1			13-11-22

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Item ID: D350-636-011GB

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/19/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 11/26/13 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230

0.00

230

HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1- Install inserts as per Dwg D2750

2-Inspect for Foreign Objects

3- Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: 11127145EXP DATE: 11/20/13

4- Assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: 111216515- Coat all exposed fasteners with "LPS Procyon" batch: 11122900164 1 13/11/26

240

QC5- Inspect part completeness to step on W/O

0.00

240

QC

Memo

0.00

Quality Control

13/11/261

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Item ID: D350-636-011GB

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/19/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 11/26/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00				1			DAS 33 9-89 12-11-26
250									
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.00							
Quality Control	*****ensure antiseize is on AN8C21A bolts*****								
270		0.00							
270	Packaging								
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-011								

13/11/27
DAS
6
9-89

13/11/27

13/11-27

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Item ID: D350-636-011GB

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/19/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 11/26/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

MLS 13-11-27

Picklist Print

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Page 1

Work Order ID: 109333

Parent Item: D350-636-011GB

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/19/13

Required Date: 11/26/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I 02.09.25 Rearranged procedure steps KJ
 IPP Rev:J 06-03-23 As per Rev D JLM
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC
 IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec
 IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010 DD
 verf:EC IPP Rev:P 10.06.22 revise seq110 DD
 verf:EC IPP Rev:Q 10.10.01 as per ITN revH DD verf:EC
 REV:R 13.08.27 PER ECN13-594 DD VERF:JLM

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3492-1
Plug

Manufactured

No

230

Each

357.0000

8

8

13/11/26

Location

Loc Qty

Loc Code

FP001

357

100504

2

B109651

x 8

101063

3

104844

283

107914

40

69531

8

74444

2

76235

4

83098

7

88541

3

91466

2

97266

3

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Page 2

Work Order ID: 109333

Parent Item: D350-636-011GB

Start Date: 11/19/13

Required Date: 11/26/13

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Qty: 1.00

Required Qty: 1.00

D3492-3
Plug



Manufactured No

230 Each 283.0000

8

8

13/11/26

Location

Loc Qty

Loc Code

FP001

243

3109652

x2

104853

102

106844

18

107331

105

81967

5

83099

3

85461

1

86865

2

95124

4

99012

3

FP002

40

107915

40

NAS1149D0863J
Washer

Purchased No

250 Each 1,124.0000

2

2

DAS
33
9-89

13-11-26

Location

Loc Qty

Loc Code

FP001

4

118078

4

ST294

1120

125268

600

125484

220

125635

300

DAS
31
9-89

125484

DAS
6
9-89

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Work Order ID: 109333

Parent Item: D350-636-011GB

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/19/13

Required Date: 11/26/13

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010
O-RING

Purchased No

230 Each 275.0000

8 *u* 8 *u* 11/13/26

Location

Loc Qty

Loc Code

FP001

275

110915

14

117460

8

118077

1

118612

3

119438

7

121259

2

121584

2

121723

7

122151

8

123348

29

123352

4

124580

4

125484

14

m126988

172

x *o*

D2744

Cap

Manufactured No

110 Each 69.0000

1 1

8K3-11-19

Location

Loc Qty

Loc Code

LG

68

100398

28

97543

40

LG002

1

62715

1

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Page 4

Work Order ID: 109333

Parent Item: D350-636-011GB

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/19/13

Required Date: 11/26/13

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT

Manufactured No

110

Each

31.0000

1

1

Extrusion Bent

Location

Loc Qty

Loc Code

LG

31

105198

1

107404

13

66875

7

73253

1

75021

1

75022

1

75023

1

81330

4

83305

1

97615

1

1 B13/11/19

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Work Order ID: 109333

Parent Item: D350-636-011GB

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/19/13

Required Date: 11/26/13

Start Qty: 1.00

Required Qty: 1.00

D2743 Manufactured No 160 Each 345.0000 8 8
Crossbolt Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	13	
106245	12	
97584	1	
LG001	270	
101033	2	
107359	131	
107907	63	
67766	4	
68251	3	
73403	64	
74445	1	
79517	2	
LG002	62	
106876	27	
81965	23	
83262	2	
85459	4	
88504	2	
95148	2	
95901	2	

B213-11-21
*B106876 * 8*

D2739 Manufactured No 160 Each 8.0000
350 I Beam

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	8	
106933	1	
107413	4	
97319	1	
97618	2	

1 B 13/11/20

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Work Order ID: 109333

Parent Item: D350-636-011GB

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/19/13

Required Date: 11/26/13

Start Qty: 1.00

Required Qty: 1.00

D3490-3
Cross Bolt Spacer

Manufactured No

160 Each 120.0000

4

4

BELB-11-21

Location	Loc Qty	Loc Code
LG	57	
103883	22	
105603	31	
92443	1	
95223	3	
LG001	63	
107913	63	

4

D3490-1
Cross Bolt Spacer

Manufactured No

160 Each 130.0000

4

4

BELB-11-21

Location	Loc Qty	Loc Code
LG	110	
101117	2	
103881	2	
105602	19	
107419	87	
LG001	16	
100560	2	
62450	2	
74875	4	
77042	3	
95977	1	
97621	2	
99074	2	
LG004	4	
81976	2	
94805	2	

4

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Work Order ID: 109333

Parent Item: D350-636-011GB

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/19/13

Required Date: 11/26/13

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

Each

1,265.0000

Rivnut

38

13/11/24

Location

Loc Qty

Loc Code

FG	30	
M127028	30	
ST280	435	
M125954	20	
M127028	415	x 3%
st555	800	
M127092	800	

D3793-3

Manufactured

No

230

Each

21.0000

Wearplate Aft

1

13/11/24

Location

Loc Qty

Loc Code

FP001	13	
104212	12	
92487	1	
FP002	8	
106663	8	x 1

AN8C35A

Purchased

No

230

Each

71.0000

Bolt

1

13/11/26

Location

Loc Qty

Loc Code

FG	5	
121275	5	
FP001	65	
115960	1	
121275	1	
m126293	33	x 1
m127061	30	
st507	1	
124827	1	

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Work Order ID: 109333

Parent Item: D350-636-011GB

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/19/13

Required Date: 11/26/13

Start Qty: 1.00

Required Qty: 1.00

D3793-1 Manufactured No
Wearplate Fwd

230 Each 13.0000

1 ll 1 13/11/26

Location	Loc Qty	Loc Code
FP002	13	
100333	1	
105532	6	
82171	2	
87273	3	
92382	1	

x1

D3488-041 Manufactured No
Blade Fitting LH

230 Each 14.0000

1 ll 1 13/11/26

Location	Loc Qty	Loc Code
FP001	14	
100823	1	
103877	8	
106696	5	

13109650

x1

D3794-3 Manufactured No
Gasket Aft

230 Each 29.0000

1 ll 1 13/11/26

Location	Loc Qty	Loc Code
FP001	29	
105529	8	
108413	18	
74530	2	
92658	1	

x1

AN6C44A Purchased No
Bolt

230 Each 130.0000

4 ll 4 13/11/26

Location	Loc Qty	Loc Code
FG	2	
103964	2	
st503	128	
m127300	128	

vd

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Work Order ID: 109333

Parent Item: D350-636-011GB

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/19/13

Required Date: 11/26/13

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased No

230 Each 92.0000

Nut

1 11 1 13/11/20

Location

Loc Qty

Loc Code

ST319

89

123900

3

125484

1

m126274

10

m127255

75

ST506

3

124308

3

D3536-25

Manufactured No

230 Each 12.0000

Gasket Center

1 11 1 13/11/20

Location

Loc Qty

Loc Code

FG

6

87053

2

95328

4

FP001

6

105965

2

83900

1

89057

1

93696

1

95686

1

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Page 10

Work Order ID: 109333

Parent Item: D350-636-011GB

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/19/13

Required Date: 11/26/13

Start Qty: 1.00

Required Qty: 1.00

D3631-1
Washer

Manufactured No

230 Each 217.0000

8

8

13/11/23

Location

Loc Qty

Loc Code

FP001

202

106188

4

106837

76

107324

100

81874

2

83588

18

91606

1

94702

1

FP002

15

68062

2

75548

13

X 8

D3791-1
Wearpad

Manufactured No

230 Each 15.0000

1

1

13/11/23

Location

Loc Qty

Loc Code

FP002

15

106144

12

62239

2

83392

1

X 1

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Page 11

Work Order ID: 109333

Parent Item: D350-636-011GB

Start Date: 11/19/13

Required Date: 11/26/13

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased No

230

Each

12,489.000

38

38

13/11/26

WASHER

Location

Loc Qty

Loc Code

FP001

264

123355

264

ST292

119

123248

18

123759

10

125268

91

st510

10344

m126319

4844

m127306

2500

m127410

3000

ST511

1636

125654

1636

ST517

126

124580

126

x 38

D2745

Manufactured No

230

Each

318.0000

8

8

13/11/26

Bushing

Location

Loc Qty

Loc Code

ST017

318

106847

120

107336

124

107908

74

x 8

AN3C5A

Purchased No

230

Each

530.0000

34

34

13/11/26

Bolt

Location

Loc Qty

Loc Code

FG

5

122800

5

ST350

525

m127290

525

x 34

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Page 12

Work Order ID: 109333

Parent Item: D350-636-011GB

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/19/13

Required Date: 11/26/13

Start Qty: 1.00

Required Qty: 1.00

D3537-1 Manufactured No 230 Each 97.0000

3 3 13/11/25

Location	Loc Qty	Loc Code
FG	18	
79833	8	
88562	10	
FP001	79	
100524	6	
107384	13	
108118	60	

NAS1149C0832R Purchased No 230 Each 252.0000

1 1 13/11/25

Location	Loc Qty	Loc Code
ST292	252	
122441	102	
m125807	150	

AN3C6A Purchased No 230 Each 759.0000

4 4 13/11/25

Location	Loc Qty	Loc Code
FG	10	
122416	10	
FP001	30	
122599	30	
FP002	1	
111982	1	
ST350	17	
122416	17	
ST512	701	
m125709	701	

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Page 13

Work Order ID: 109333

Parent Item: D350-636-011GB

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/19/13

Required Date: 11/26/13

Start Qty: 1.00

Required Qty: 1.00

NAS1611-013

Purchased No

230 Each 230.0000

8 ll 8 13/14/21

O-RING

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	230	
116582	5	
117291	2	
117887	53	
119623	36	
121825	10	
122993	3	
124231	1	
<u>125445</u>	120	

x8

D3535-25

Manufactured No

230 Each 26.0000

1 ll 1 13/14/21

Wearplate Center

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	2	
95077	2	
FP002	24	
<u>105549</u>	9	
106128	11	
62233	1	
81357	1	
87385	1	
90061	1	

x1

D3794-1

Manufactured No

230 Each 15.0000

1 ll 1 13/14/20

Gasket Fwd

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	15	
101046	1	
<u>104620</u>	2	
108497	8	
87631	2	
92426	1	
95913	1	

x1

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Work Order ID: 109333
 Parent Item: D350-636-011GB
 Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/19/13

Required Date: 11/26/13

Start Qty: 1.00

Required Qty: 1.00

MS21043-6 Purchased No 230 Each 342.0000 4

NUT

Location Loc Qty Loc Code

FG 20

103693 20

ST315 256

117887 2

120308 2

124231 2

m127255 250

ST506 66

124485 66

DAS
6
9-89

D3493-1 Manufactured No

Washer

250 Each 118.0000 2

Location Loc Qty Loc Code

FG 10

97201 10

ST051 108

105613 48

107916 60

MS21083C8 Purchased No

Nut

250 Each 92.0000 2

Location Loc Qty Loc Code

ST319 89

123900 3

125484 1

m126274 10

m127255 75

ST506 3

124308 3

DAS
6
9-89

DAS
33
9-89

9-89

DAS
33
9-89

9-89

13-11-26

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Work Order ID: 109333
 Parent Item: D350-636-011GB
 Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/19/13 Required Date: 11/26/13
 Start Qty: 1.00 Required Qty: 1.00

AN8C21A Bolt Purchased No 250 Each 79.0000 2

DAS 33 9-89

DAS 6 9-89

Location	Loc Qty	Loc Code
ST	2	
123966	2	
ST342	2	
123966	2	
ST505	75	
m127061	75	

NAS1515H3L Washer Purchased No 230 Each 205.0000 4

127061
 4 13/11/25

Location	Loc Qty	Loc Code
FG	40	
102472	40	
ST297	165	
121556	45	
124542	120	

D2741 Blade Manufactured No 250 Each 17.0000 1

x 4
 109634

DAS 6 9-89

Location	Loc Qty	Loc Code
FG	11	
100664	6	
85480	1	
98323	4	
ST466	6	
104976	3	
71856	1	
85480	1	
98323	1	

DAS 33 9-89

D3532-1 Spacer Manufactured No 250 Each 42.0000 2

DAS 33 9-89

13-11-26

DAS 6 9-89

Location	Loc Qty	Loc Code
ST054	42	
100519	42	

100519

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QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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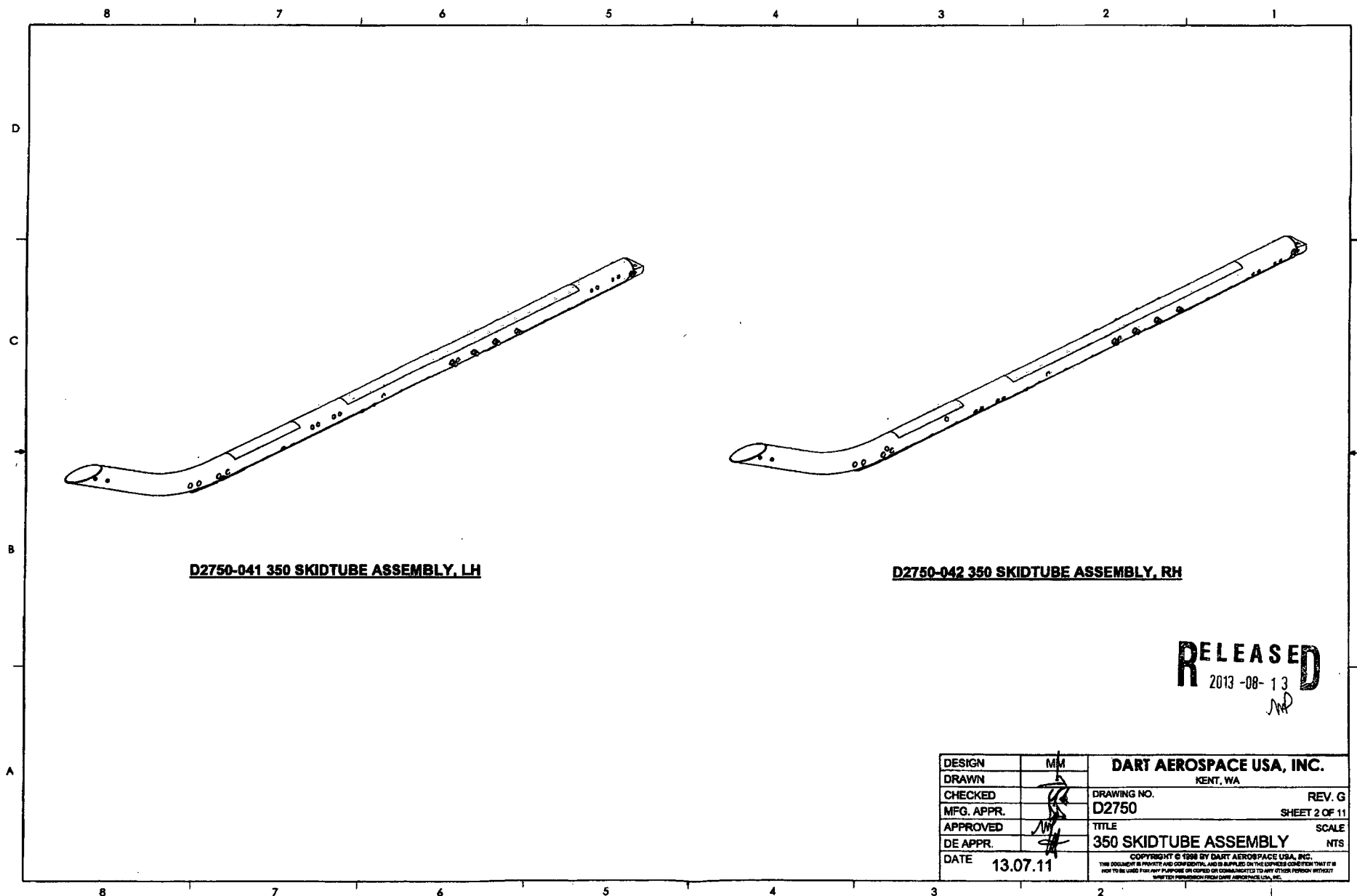
W/O 102333

G	CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS +0.010/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413: QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A8-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.07.11		

DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO.
D2750
TITLE
350 SKIDTUBE ASSEMBLY
REV. G
SHEET 1 OF 11
SCALE
NTS

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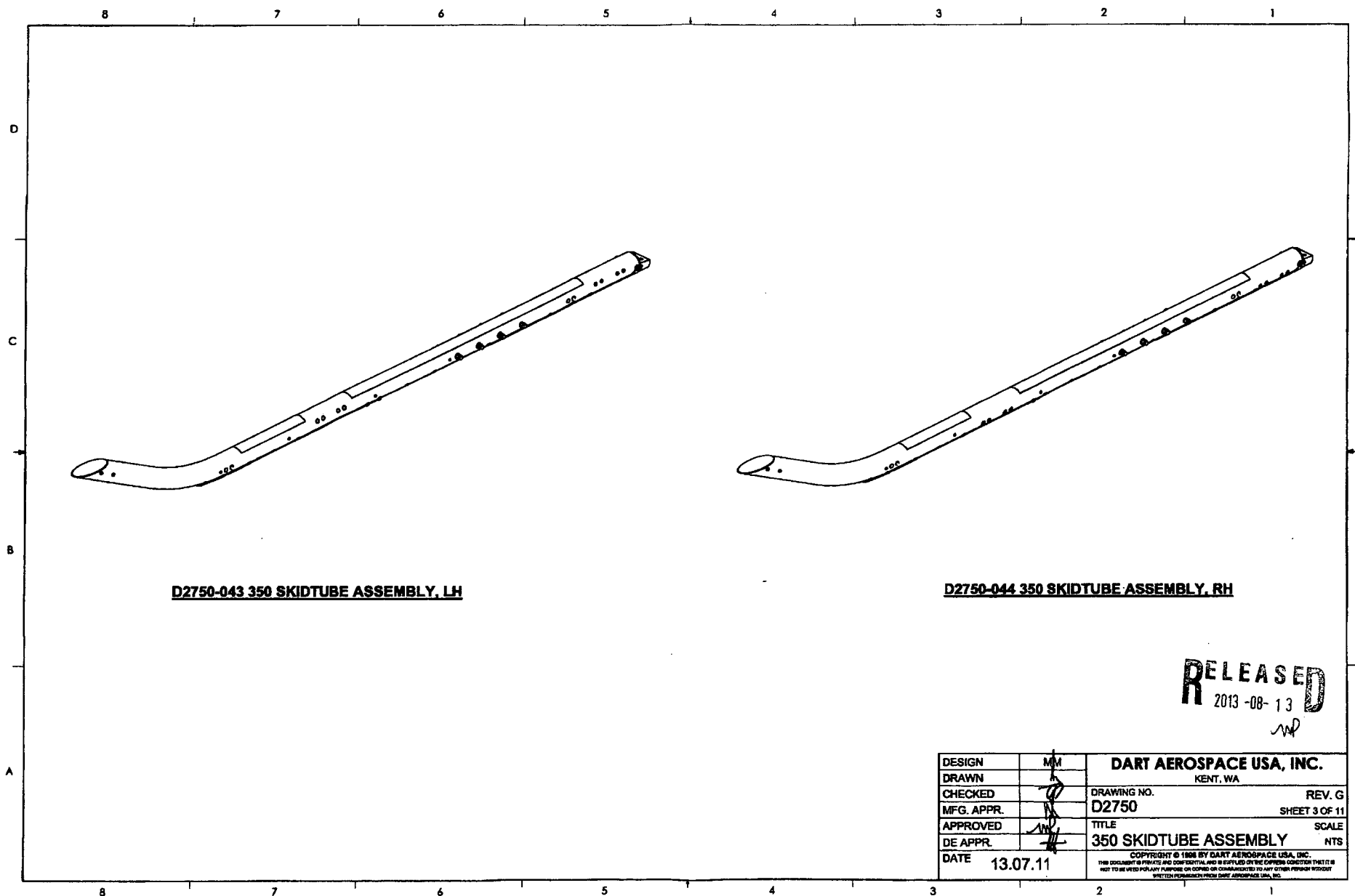


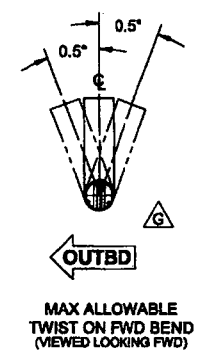
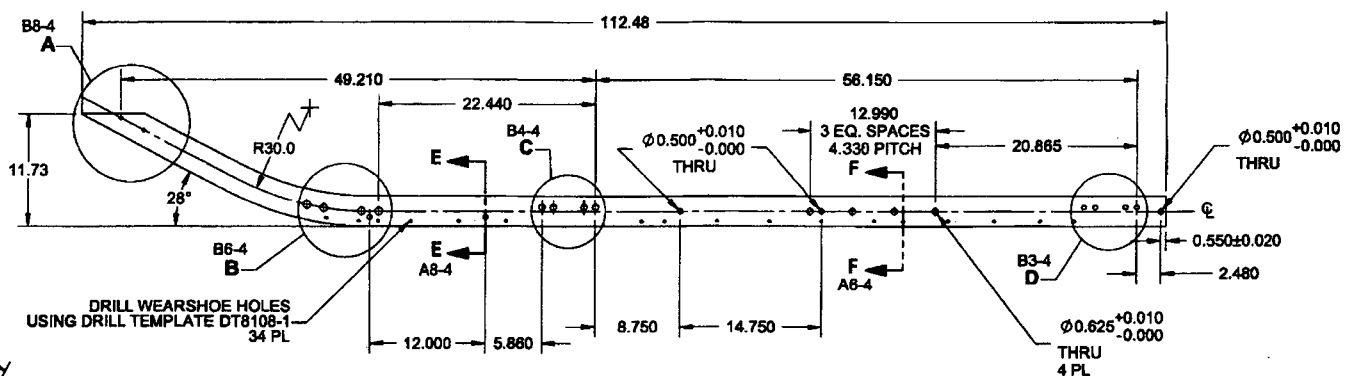
D2750-041 350 SKIDTUBE ASSEMBLY, LH

D2750-042 350 SKIDTUBE ASSEMBLY, RH

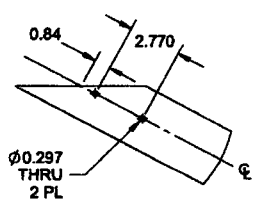
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MFG. APPR.		D2750	SHEET 2 OF 11
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DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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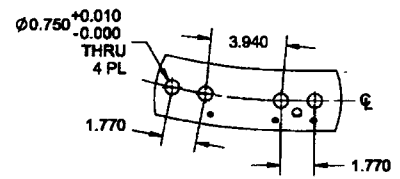




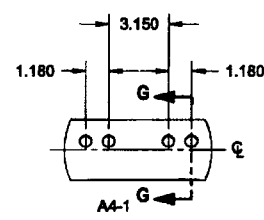
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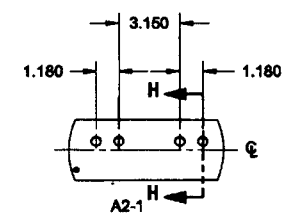
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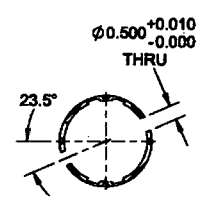
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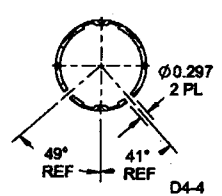
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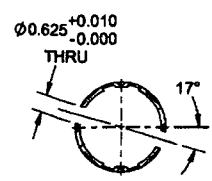
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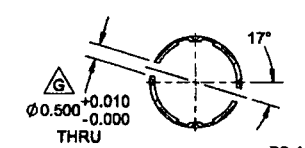
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL

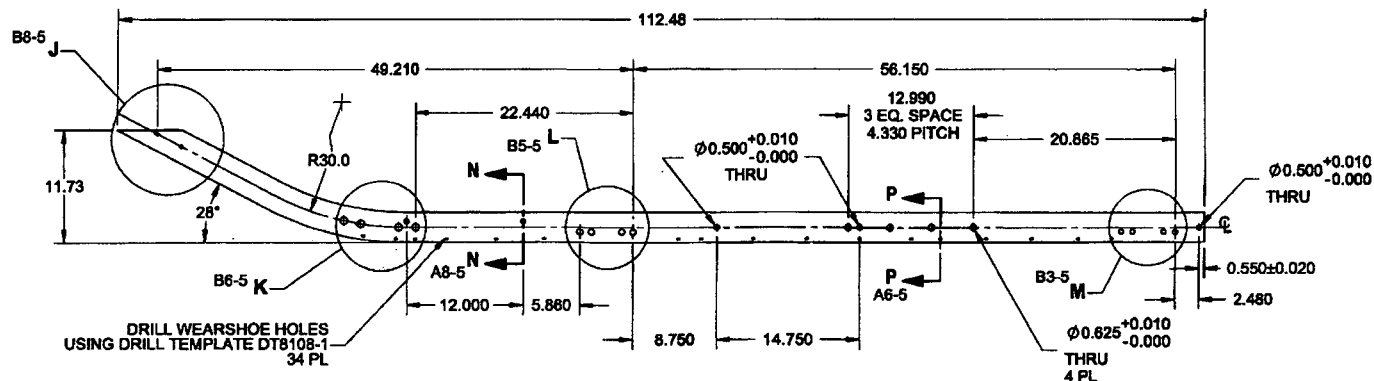


SECTION H-H
SCALE 3X, 4 PL

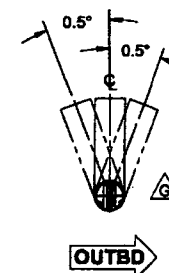
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APPROVED		TITLE	SCALE
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DATE	13.07.11	NTS	

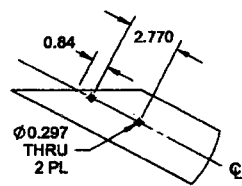
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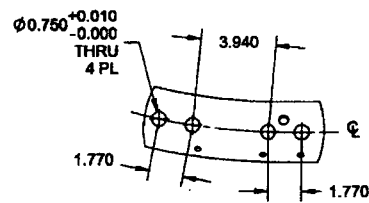
D2750-2 RH SKIDTUBE



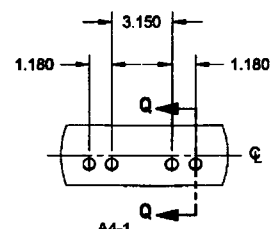
MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)



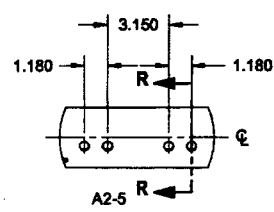
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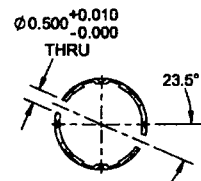
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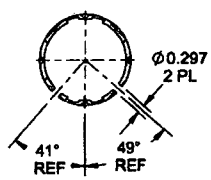
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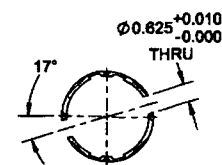
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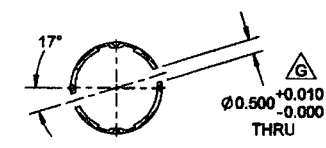
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SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL

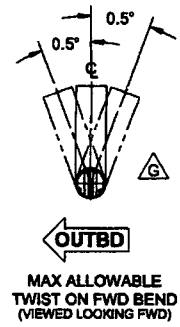
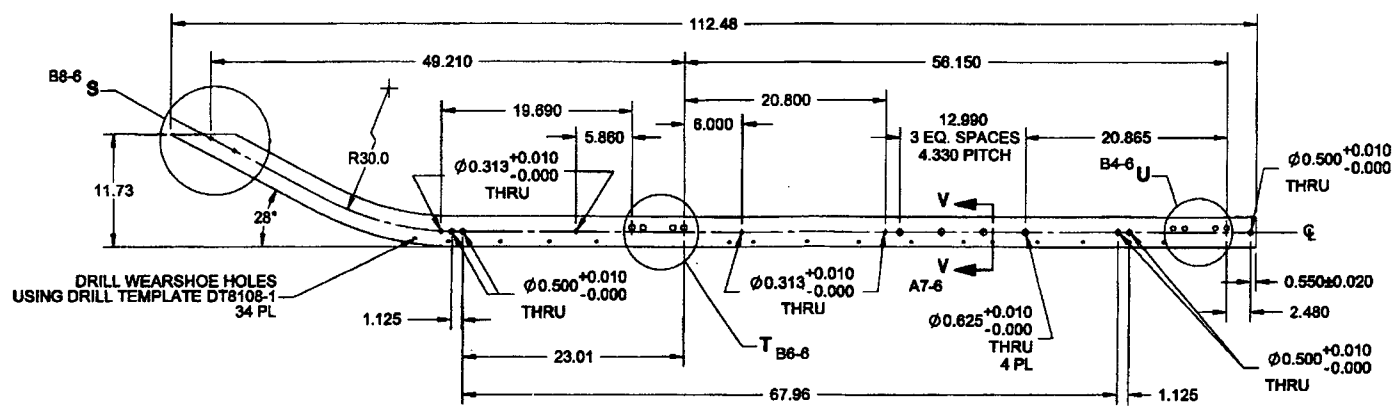


SECTION R-R
SCALE 3X, 4 PL

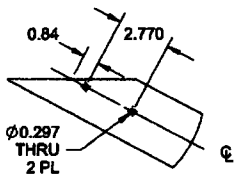
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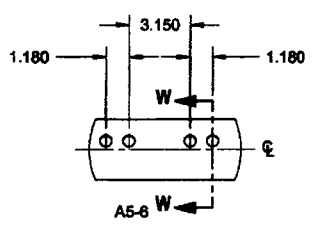
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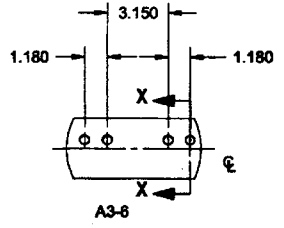
D2750-3 LH SKIDTUBE



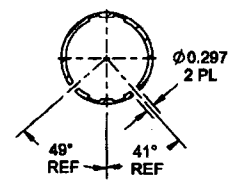
DETAIL S
D8-6
SCALE 2X



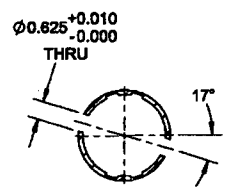
DETAIL T
C5-6
SCALE 2X



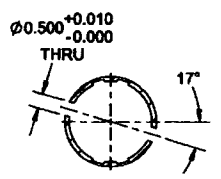
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D3-6
SCALE 2X



SECTION V-V
C4-6
SCALE 3X, 17 PL



SECTION W-W
B8-6
SCALE 3X, 4 PL

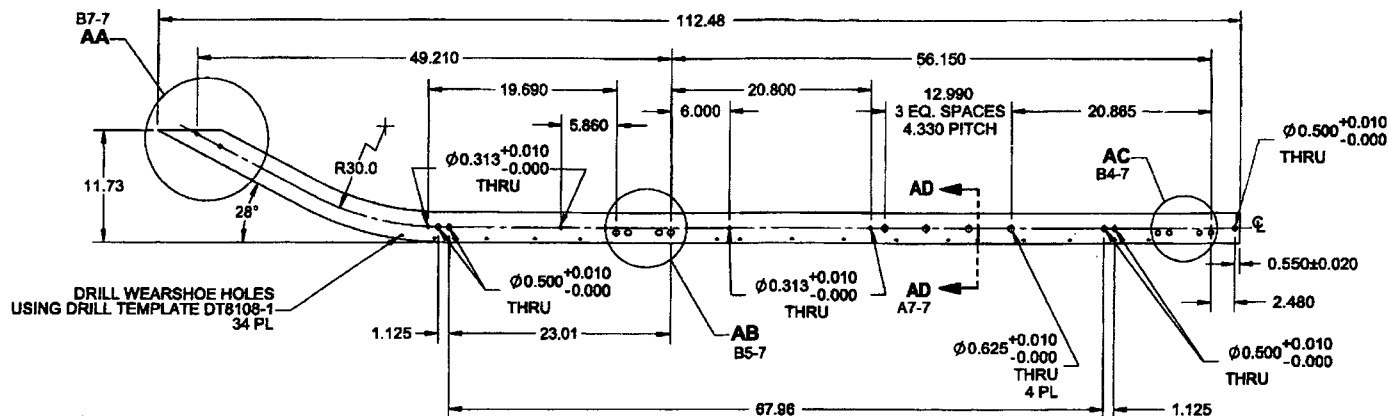


SECTION X-X
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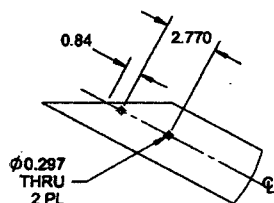
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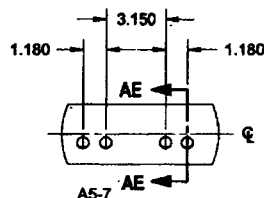
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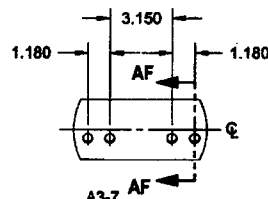
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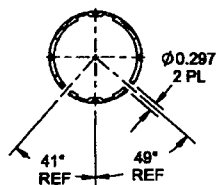
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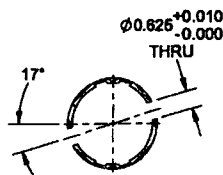
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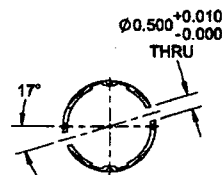
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SECTION AD-AD
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SCALE 3X, 17 PL



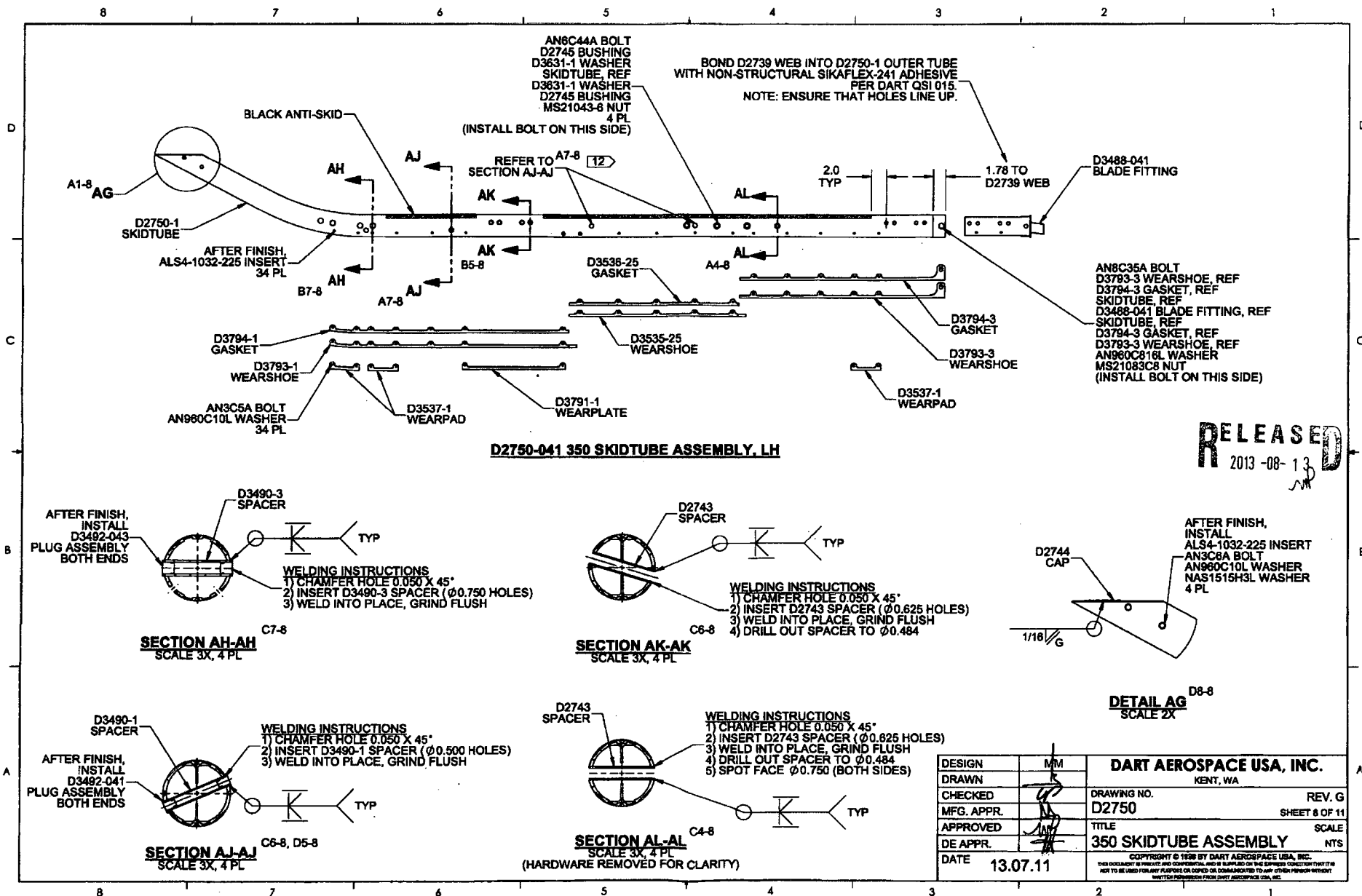
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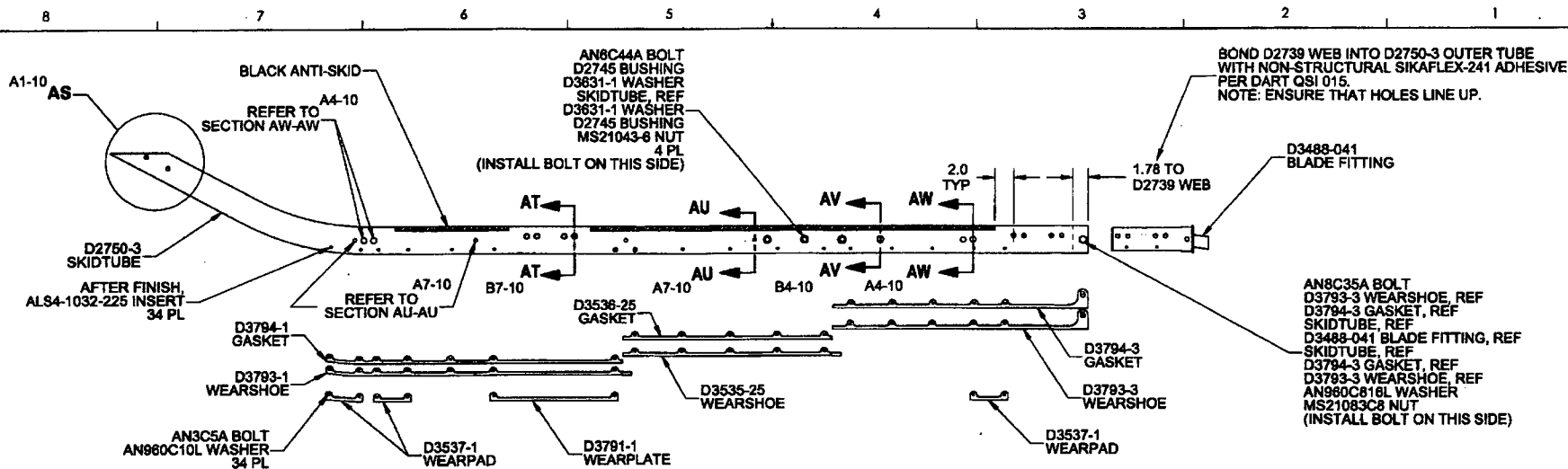


SECTION AF-AF
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SCALE 3X, 4 PL

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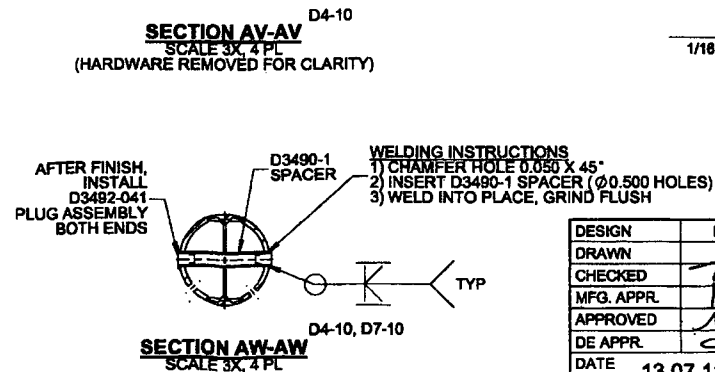
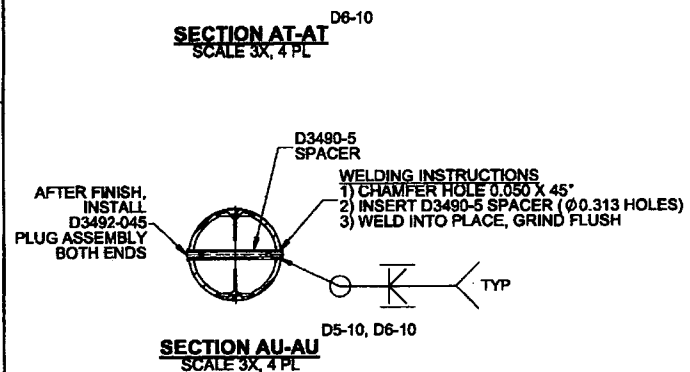
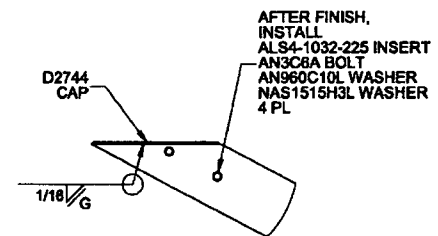
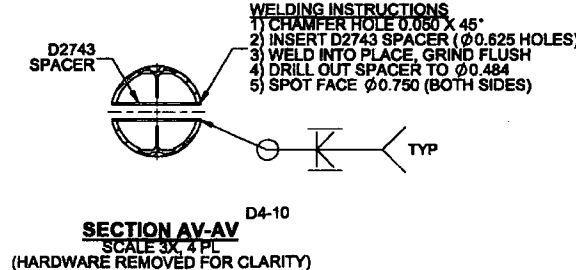
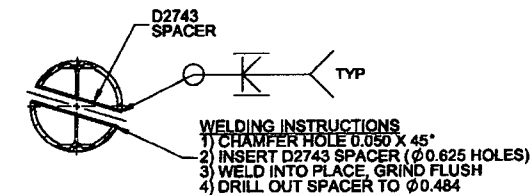
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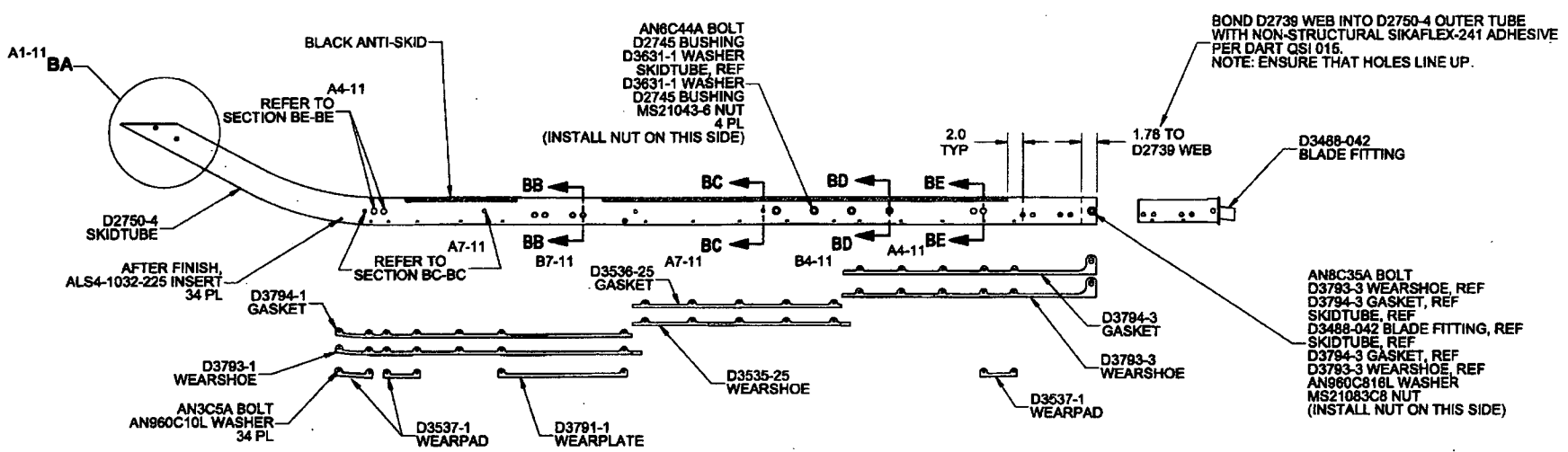
D2750-043 350 SKIDTUBE ASSEMBLY, LH

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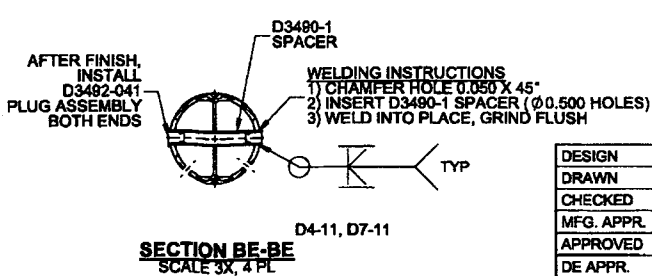
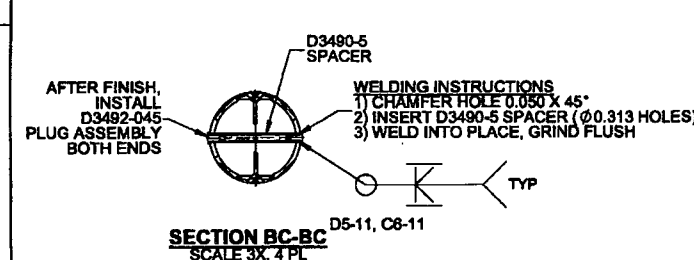
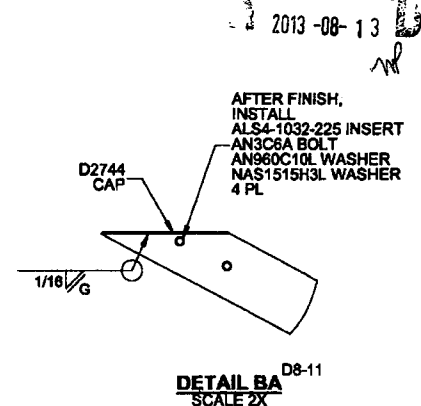
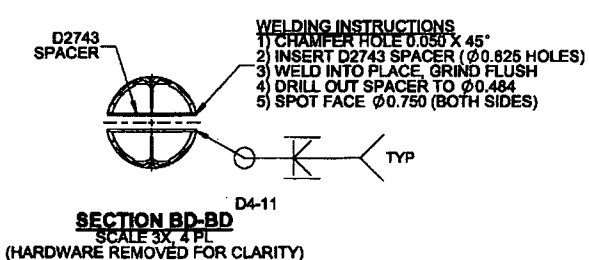
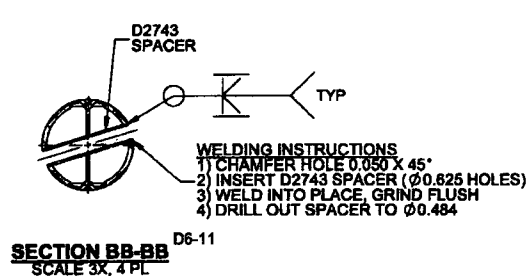


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8 7 6 5 4 3 2 1



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NO. 335

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Bardley Elliott
Job #: 107182
Part #: D350.636-015
Description: 350 skid tube
Welding Process: Tig[✓] Mig[]
Base materiel: Aluminium
Current: AC[✓] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:	pass[✓]	fail[]
Incomplete Penetration:	pass[✓]	fail[]
Incomplete Fusion:	pass[✓]	fail[]
Cracks:	pass[✓]	fail[]
Overlap (cold lap)	pass[✓]	fail[]
Undercut:	pass[✓]	fail[]
Pin holes:	pass[✓]	fail[]
Porosity (surface):	pass[✓]	fail[]
Coloration:	pass[✓]	fail[]
Burn through:	pass[✓]	fail[]

Qualifier 9-88 Date of Test Coupon 15-11-07

Welder Harley Elliott Date of Test Coupon 13-11-07

The above named individual is qualified in accordance with AWS D17.1.2001 to weld